

Work Order ID 65267

January 10, 2011 10:48:52 AM



Page 1

Item ID: D3571-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 1/10/11 Start Qty: 12.00



Cust Item ID:

Required Date: 1/19/11 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: MF Date: 11-01-10

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3571	Rev A								

100

0.00



BAND SAW

0.00

mf 11/01/12

12 ~~0~~

Bandsaw

Memo

Jeaspa Bandsaw

Cut blank 2.90 " long

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

mf 11/01/13

12 ~~0~~

HAAS 1

Memo

HAAS CNC vertical machine #1

1- Mill as per Folio FA675Rev: AA & Dwg D3571 Rev: A ☐ 2-Deburr
per dwg D3571

120

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

mf 11/01/13

12 ~~0~~

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



Y.A 11/01/13

12

0

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



12

0

11/01/13

HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



11/25/13

12 BL 11-01-14.

Powdercoat

Memo

0.00

Powder Coating

START TIME:

8:10

OVEN TEMPERATURE:

320 FINISH TIME:

8:40

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Cust Item ID:

Required Date: 1/19/11 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish 0.00



QC Memo 0.00

Quality Control

12 of 12 located

170 Identify as per dwg & Stock Location 245 0.00



Packaging Memo 0.00

Packaging

11/1/14 SP120

180 QC21- Final Inspection - Work Order Release 0.00



QC Memo 0.00

Quality Control

11/01/17

ME 11-01-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 10, 2011 10:48:51 AM

Page 1

Work Order ID: 65267



Parent Item: D3571-1



Parent Item Name: Guide

Start Date: 1/10/11

Required Date: 1/19/11

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			100	f	25.9944	0.241	3.044211			



6061-T6 Bar .750 X 1.50

Location

Loc Qty

Loc Code

MAT

25.9944

116405

25.9944

3.044 gml 11/01/12

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order: 65267
Description: Guide		Part Number: D3571-1
Inspection Dwg: D3571	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.698	+/-0.010	.699	—		Vern	M-L-7
Ø1.00 Depth 100	+/-0.010	Ø.999 x 100	—		"	"
2.75	+/-0.030	2.750	—		"	"
1.38	+/-0.030	1.375	—		"	"
1.25	+/-0.030	.1245	—		"	"
0.63	+/-0.010	.622	—		"	"
0.031 chamfer	+/-0.010	.025	—		"	"
Ø0.500	+0.006/-0.001	Ø.501	—		"	"
Ø0.201	+0.005/-0.001	Ø.203	—		"	"
R0.25	+/-0.030	R.250	—		"	"
0.260	+0.000/-0.010	.255	—		"	"
Ø0.385 x 100°	+0.006/-0.001 x 0.5°	Ø.386 x 100°	—		"	"
0.125	+/-0.010	.126	—		"	"
2.250	+/-0.010	2.241	—		"	"
0.250	+/-0.010	.254	—		"	"
0.188	+/-0.010	.190	—		"	"
0.063 chamfer	+/-0.010	.063	—		"	"

Measured by:	awf
Date:	11/01/13

Audited by:	B.A
Date:	11/01/13

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.16	New Issue	KJ/JLM	

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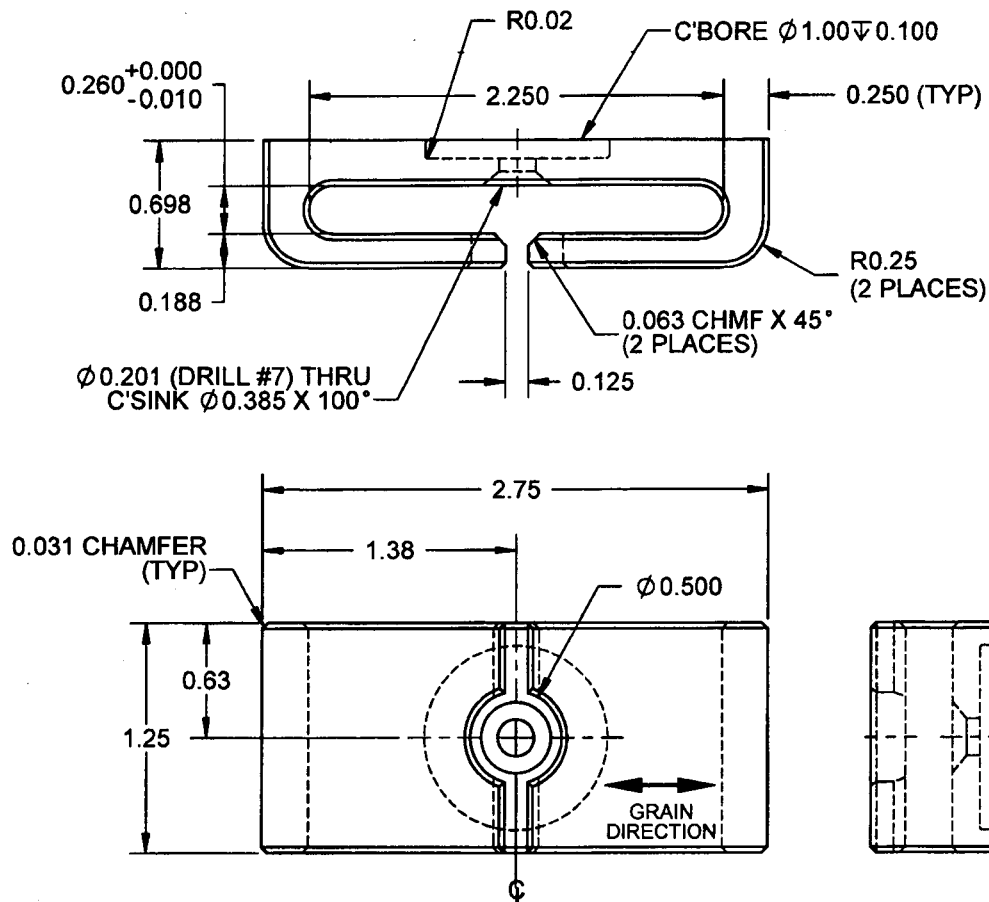
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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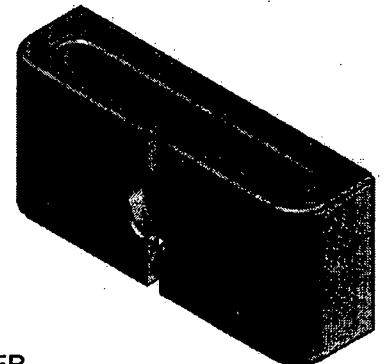
NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3571	REV. A SHEET 1 OF 2
DATE 07.01.29	TITLE GUIDE SCALE 1:1		
REV A	DATE 07.01.29	DESCRIPTION NEW ISSUE	

RELEASED07.04.12 *[Signature]***D3571-1 GUIDE****NOTES:**

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER QQ-A-225/8 OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS 4160 (REF DART SPEC M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3571-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) PART IS SYMMETRIC ABOUT ϕ

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